

Customer : CU-DAR001 Dart Helicopters Services Job Number : 34467 Estimate Number : 10227 P.O. Number : N/A This Issue : 9/7/2007 S.O. No. : N/A Prsht Rev. : NC First Issue : N/A Type : SMALL /MED FAB Previous Run : 33885 Written By : _____ Checked & Approved By : _____ Comment : Est C 00-40-23 Re-format (mpp 2101) EC Est Rev:D 06-04-28 Manufactured on Water Jet JLM Est Rev:E 06-11-24 As per Rev B JLM	Drawing Name : DOUBLER Part Number : D2151 Drawing Number : D2151 REV B Project Number : N/A Drawing Revision : B Material : N/A Due Date : 9/14/2007
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Qty: 20 Um: Each

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0 M2024T3S040 2024-T3 .040 sheet

Comment: Qty.: 0.0368 sf(s)/Unit Total : 0.7350 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040) Batch:

Batch: M105225 (2) Scrap

M104025 (1) Scar

M 103 321

4B 07-09-11

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2151

Dwg Rev: 13

Prog Rev: 3

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

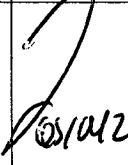
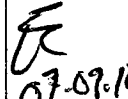
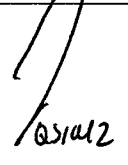
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/10	2	Scrap 2 part because Dxf was not correct 0.250 was suppose to be 0.231	 05/10/12	Scrap - destroy - replace <u>fix Dxf "program"</u>	SAD 07/09/10  07-07-10	Er 07/09/11	 05/10/12	Er 07/09/16

NOTE: Date & initial all entries

Date: Friday, 9/7/2007 10:15:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER



Job Number: 34467

Part Number: D2151

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 07-09-13

7.0

POWDER COATING

POWDER COATING



(20)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ml 07-09-14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



07-09-14-20

Comment: INSPECT POWDER COAT

el (ml)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5717

07/09/14

(20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/14

Job Completion



07/09/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

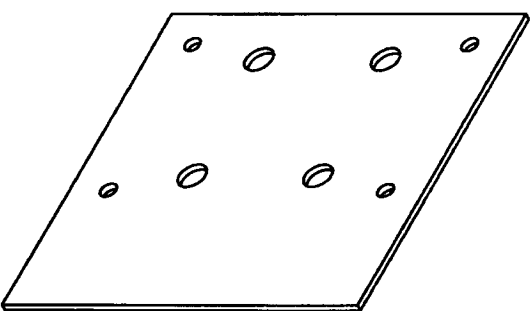
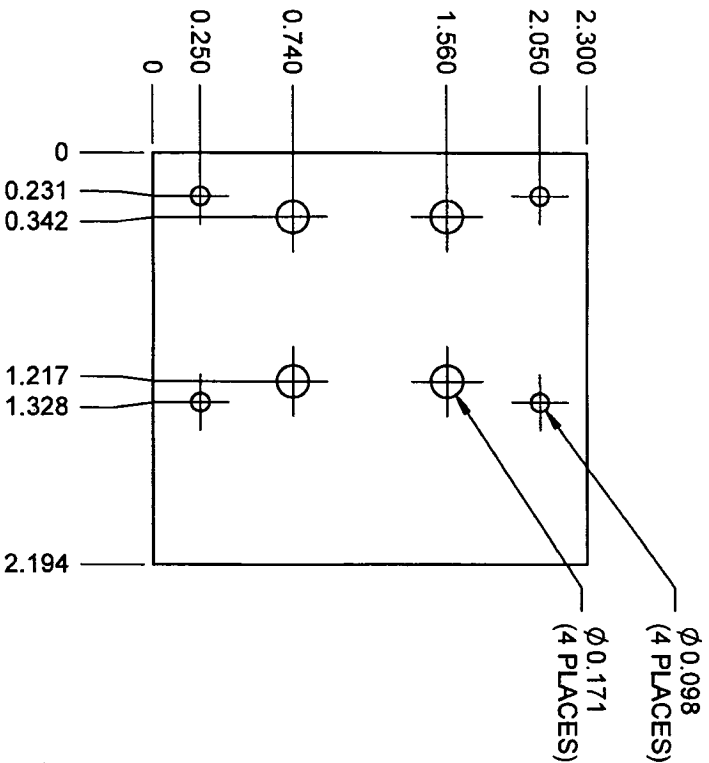
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2151
DATE 06.10.13	TITLE PACKER	REV. B SHEET 1 OF 1
REV A	DATE 95.05.01	DESCRIPTION NEW ISSUE
B	06.10.13	UPDATE DRAWING

RELEASED

cc. 11-20



D2151 PACKER

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4087 CONTROLLED COPY (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *54467*

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DART AEROSPACE LTD		Work Order:	34467
Description: DOUBLER		Part Number:	D 2151
Inspection Dwg: D2151	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by: HB	Audited by: EP	Prototype Approval: N/A
Date: 07-01-11	Date: 07/01/11	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	